

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010872**Date Inspected:** 21-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4F-184 located on PCMK SSD11A-PP93 of 10CW welder is identified as 037932. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

FCAW welding of weld joint 2F-019 located on PCMK SP599-001 of 11DE welder is identified as 058551.ZPMC QC is identified as Mr.Zhong guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

**OUTSIDE SEGMENT**

SMAW welding of weld joint 4G-007 located on PCMK SEG053A of 9CW welder is identified as 067183.ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as

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## WELDING INSPECTION REPORT

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Segment 8AW. The weld designations reviewed are as follows:

SEG043E-049,050,051,040,041,042,043,013,014,015.

SEG043D-019,020,021,083,084,085,074,075,076,137,138.

SSD10A-PP62-168,169,174,175,177,178.

SSD11A-PP63-164,165,170,171,172,184,185,207,208.

SSD12A-PP64-170,171,172,173,175,176,177.

SSD11A-PP63-184-Rejected, 2 longitudinal indication found=10mm,L=15mm.Incident report written for this incident.

During a Magnetic Particle Testing (MT) verification of welds located at Segment 8AW, the Caltrans Quality Assurance (QA) Inspector discovered two (2) 10mm,15mm linear indications. Additional information identifying the non-conformance issue is listed below.

-Two (2) Longitudinal linear indications measuring approximately 10mm and 15mm in length.

For more information please see the Incident report.

04-0120F4\_TL-15\_B247\_12-21-09\_8AW\_\_MT\_Longitudinal\_Indications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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